

Date: Wednesday, 07/01/2009 8:52:25 AM
 User: Julie Dawson

Process Sheet

8000

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L FWD X-TUBE
 Job Number : 44140
 Estimate Number : 10553
 P.O. Number :
 This Issue : 07/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D206667103
 First Issue : / / Type : CROSSTUBES Drawing Number : D206-667-143 REVC
 Previous Run : 44139 Project Number : N/A
 Material :
 Due Date : 27/01/2009 Qty: 1 Um: Each

Written By : JLD 09.01.07

Checked & Approved By : JLD 09.01.07

Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
 Skidtubes KJ/JLM
 Est Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD
 verified by:
 Est Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified by:
 EC
 Est Rev:I 08-12-15 add magnobond DD verified by:EC
 Est Rev J 09.01.06 ECN 08-562 EC verified by: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC



DOCUMENT CONTROL

H for JLD 09/01/28
DSI 9439 Rev. A

S
09/01/28



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-103 CHG003

004 per ECN 08.593

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D206667103TRN

Crosstube Turning DetailL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B-44379*

MB
09-01-07

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-143 using CNC bender program 206B-fw and Folio FT_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206L FWD X-TUBE

Job Number: 44140

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

809/01/07 (X)

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.
- 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.
- 4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.
- 5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.
- 6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143.
Note: Fwd side has 3x top holes.
- 7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.
- 8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.
- 9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143
- 10-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143
Inside of Cuff (Do not engrave on outside of tube)

(P.D.)

MB
09-01-13

MB 09-01-14

MB 09-01-13

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB
09-01-14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

809/01/14 (X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/01/14 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-103 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ND Date: 09/02/103

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44140</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/14	# 6.7	During inspection found on only 1 cuff that the Drill bit touched the other side on the inside of the cuff	UP 09.01.14 per QSI 042	Debur / buff as best possible Acceptable	MP 09-01-14	S 09/01/14	UP 09.01.14 per QSI 042	S 9/1/14
		causing a small dimple. RL employee went too deep while Drilling the 0-323" hole on the aft side						S 9/1/14
		of the x-tube on the inside of the cuff.						S 9/1/14

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 44140

Part Number: D206667103

Job Number: 4



Seq. #: Machine Or Operation: Description :

10.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



FD 8/30

U

09-01-19



Comment: Sub-Contracting OUTSIDE SERVICE -CROSSTUBES

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

P 9/10/19 (1)

12.0

QC5

INSPECT WORK TO CURRENT STEP



ml 09 01 19



(1)

Comment: INSPECT WORK TO CURRENT STEP

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 09 01 19 (1)

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ET 09-01-20

15.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate 43176

ml 09 01 19

16.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 42784

ml 09 01 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 44140

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D28911

2.25 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2891-1 Support 38122

ml 09 01 21

18.0

D3595063395

rubber cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION .63" x 3.95"

342998

ml 09 01 21

19.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-20 Clamp 109269

ml 09 01 21

20.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet 109297

ml 09 01 19

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.

A/R Magnobond 6398: 109900

ml 09 01 21 (1)

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

ml 09 01 22 (1)

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

ml 09 01 19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 206L FWD X-TUBE

Job Number: 44140

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-01-22 (1)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

24.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: 110363

SS 09/01/28 (X)

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut
Batch: M109297

SS 09/01/28 (X)

26.0

AN57A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
10 AN5-7A Bolt M10363

SS 09/01/28 (X)

27.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
4 AN5-30A Bolt M109297

SS 09/01/28 (X)

28.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
18 AN960JD516 Washer M109752

SS 09/01/28 (X)

28.0 12 X AN975-4 B M110704 per ECN 08-593

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FWD X-TUBE

Job Number: 44140

Part Number: D206667103

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/02/02 (41)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-103.

Location: S3

PPP Rev: D

9/2/02

SEP

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

Job Completion



U 09.02.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

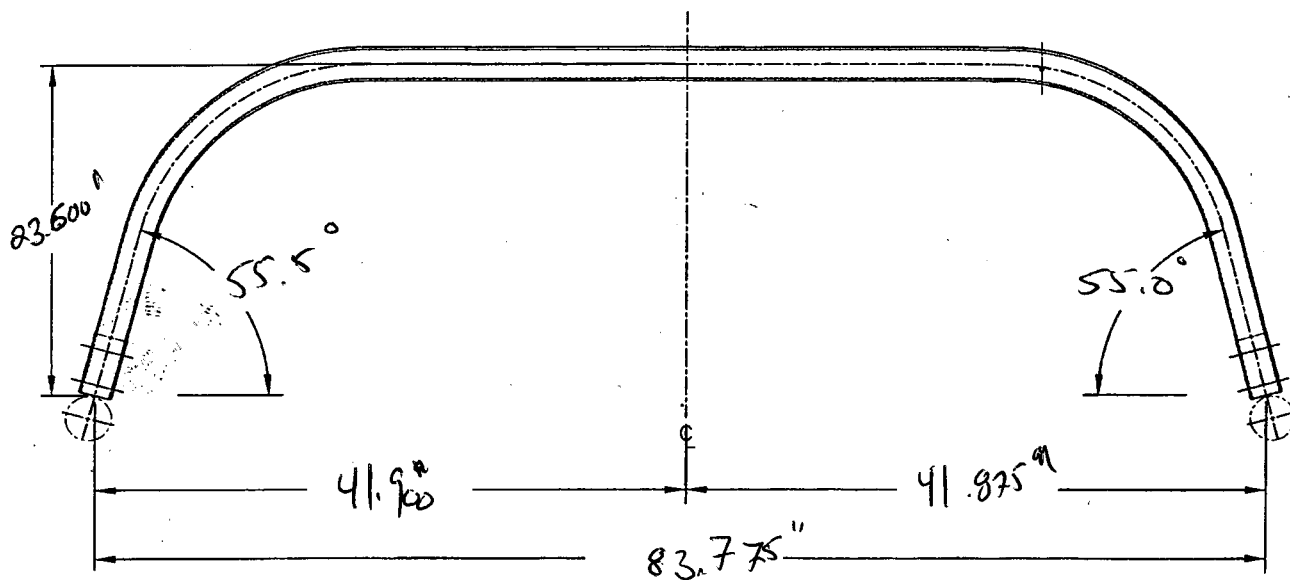
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44140	
Description: Crosstube High Fwd (206L)		Part Number: D206-667-103	
Inspection Dwg: D206-667-143		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	8/10/06
Date	8/10/06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]

Item	Qty -143	Part No
1	X	D206-66
2	1	D6002-1
3	2	D2873-0
4	2	D2873-0
5	2	D2891-1
6	4	D3595-0
7	4	MS2192
8	14	MS2060
9	A/R	MAGNO

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURE
FINISHED LENG
- 2) FINISH: CHEMICAL CONVE
PRIME INSIDE AND
PAINT OUTSIDE PE
- 3) TOLERANCES ARE PER DAR
- 4) UNITS: INCHES UNLESS OT
- 5) BREAK SHARP EDGES: 0.009
- 6) IDENTIFICATION: SCRIBE D
INSIDE OF CUFF USING VIB
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT
- 9) RUN CUTTER OFF PART WH
TRANSITION SHOULD BE S
- 10) BEND PROGRESSIVELY WITH
TO BENDING IS 6% BASED Q
- 11) LIQUID PENETRANT INSPEC
ADD TOLERANCE (ZN D3-3, C4-3, C5-3);
- 12) INSTALL D2891-1 SUPPORT S #6 (ZN A8-3) PER NCR 210; MOVED
QSI 015. LET CURE FOR 12
- 13) INSTALL MS21920-20 CLAMP NUT PLATES FOR COMPATABILITY
THE D2891-1 SUPPORT ON TUBES
- 14) EXTREME CARE MUST BE T
OUTSIDE SURFACE MUST B
SCRATCHES, NICKS, OR DE
LONGITUDINALLY. CIRCUM
- 15) TORQUE CLAMPS 80 TO 100
SAFETY AND THAT NUT HAS

RELEASED
06/11/15

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 44140

NOTES/PART LIST (ZN D7-1); VIEWS AND REFORMATTED DRAWING STANDARDS.	RF	08.11.06
AS D2856-400-694 (ZN D6-2 & A5-2); ADD TOLERANCE (ZN D3-3, C4-3, C5-3); S #6 (ZN A8-3) PER NCR 210; MOVED & UPDATED TOLERANCE TO SHEET 4.	PH	05.07.26
	CP	00.11.17
DESCRIPTION	BY	DATE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV: C
D206-667-143 SHEET 1 OF 4

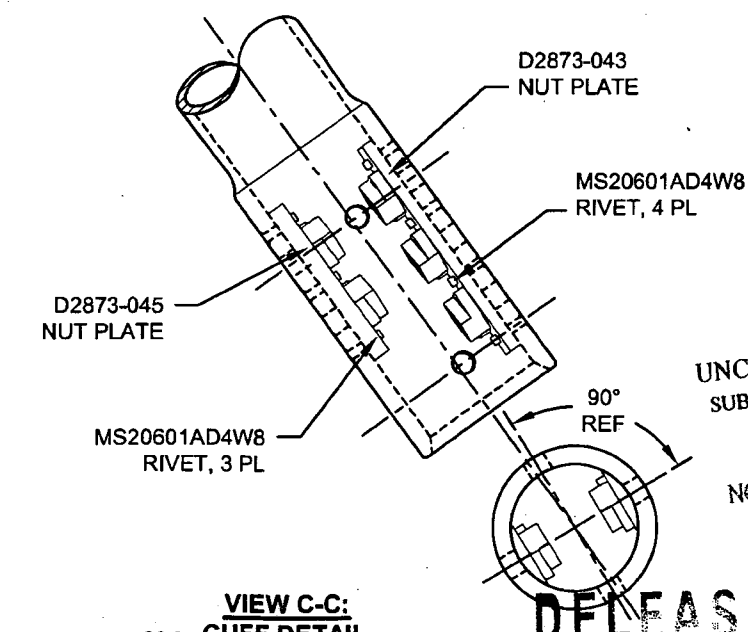
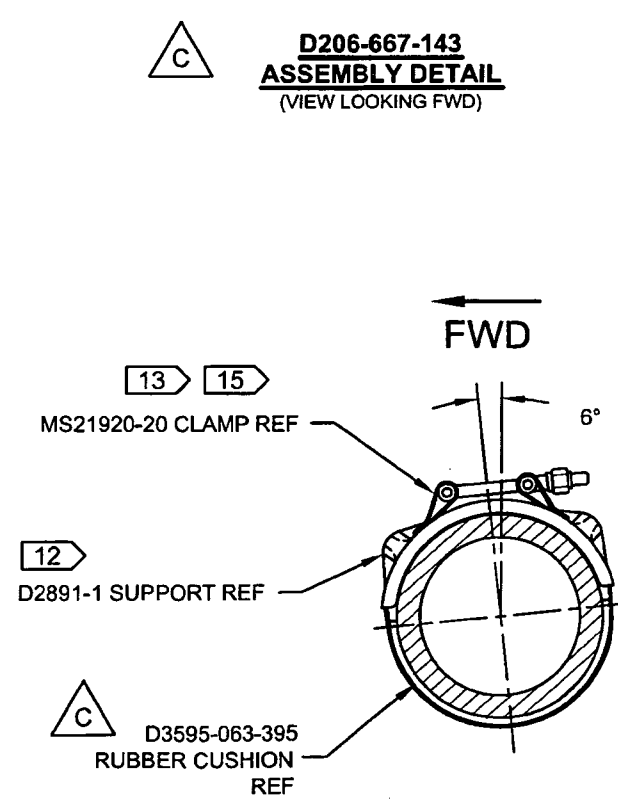
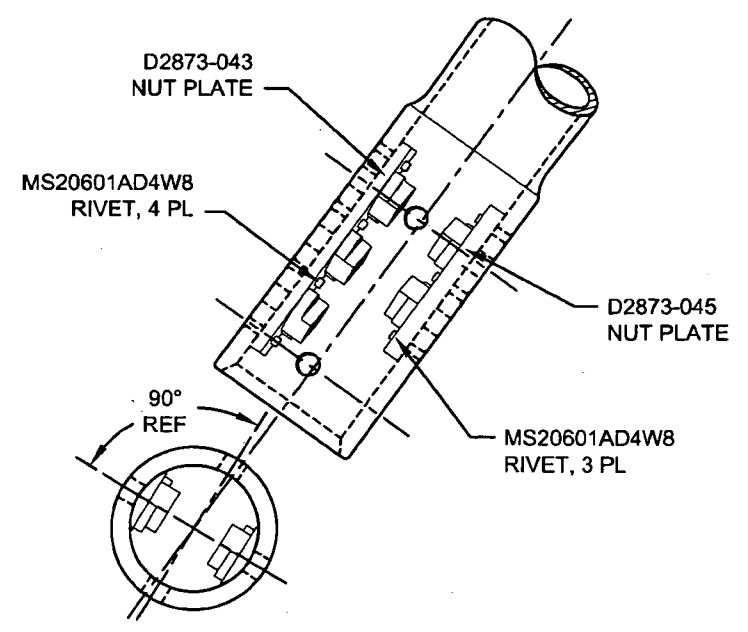
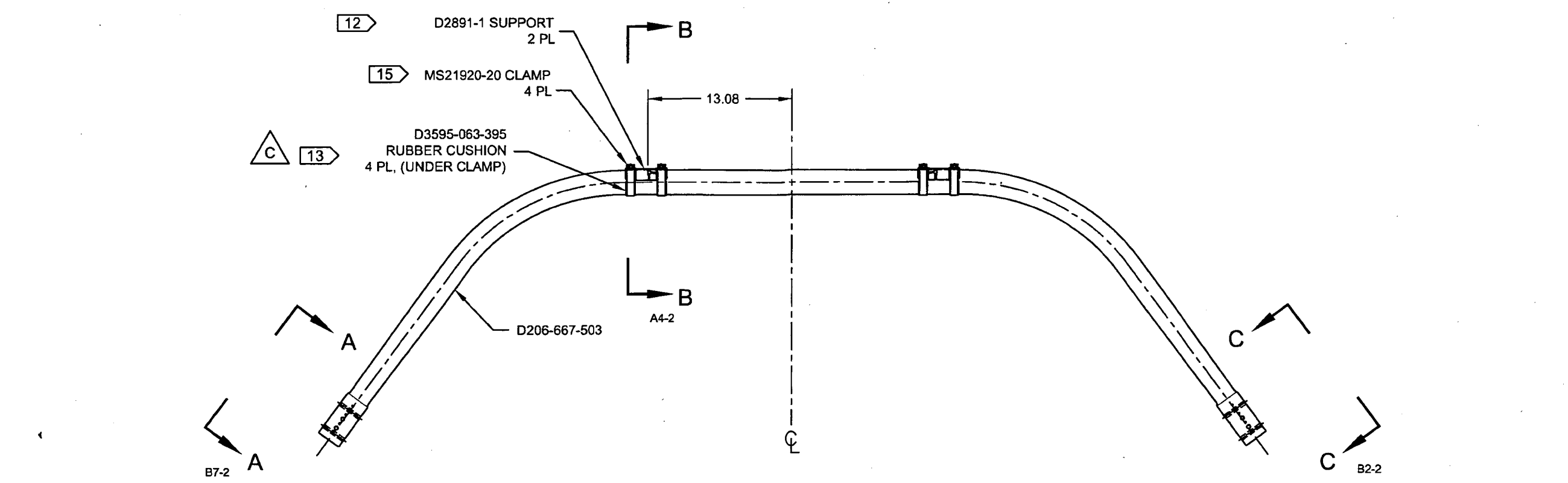
TITLE SCALE
CROSSTUBE ASS'Y (206L HIGH FWD) NTS

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8 7 6 5 4 3 2 1

D
C
B
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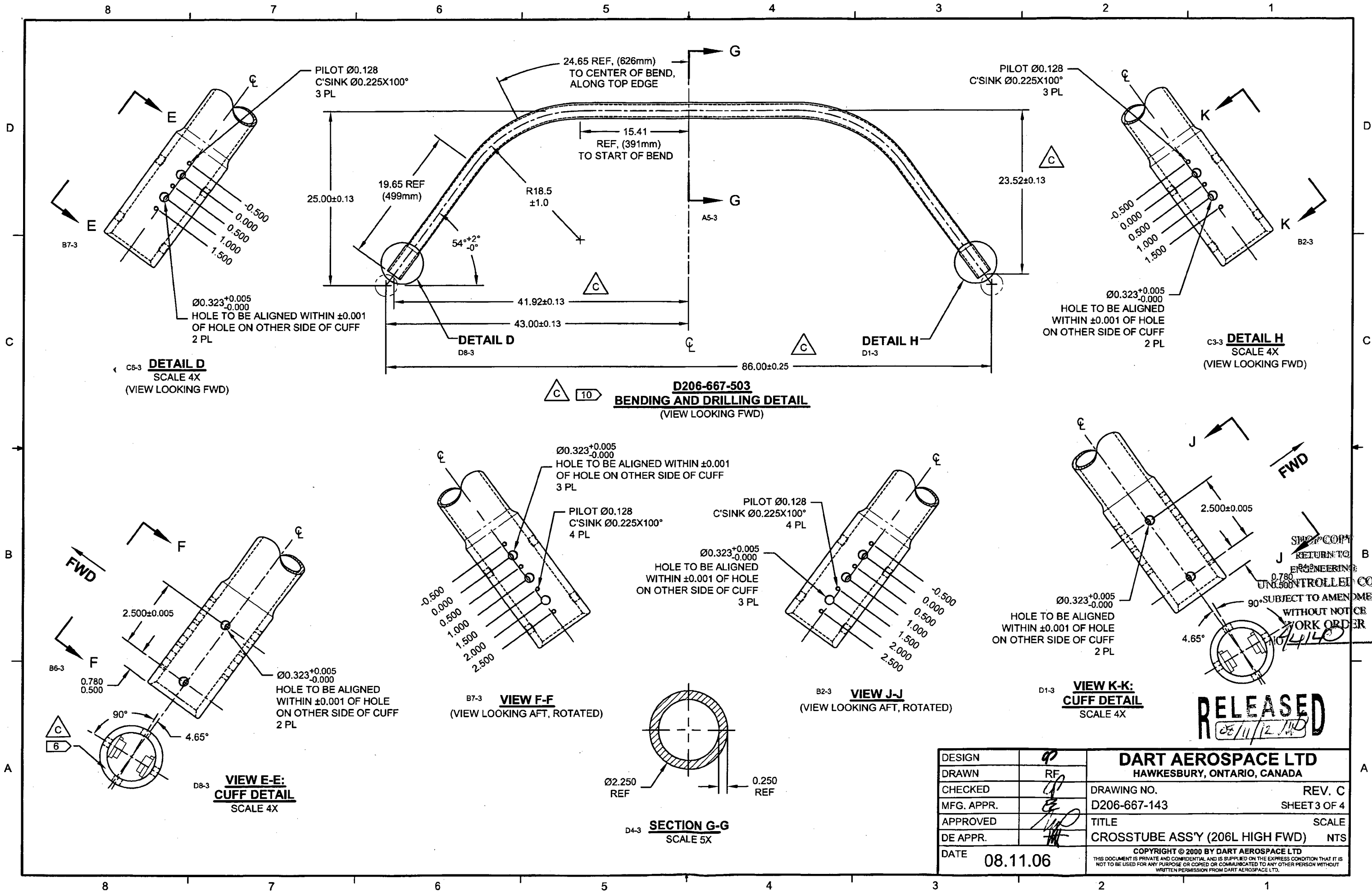
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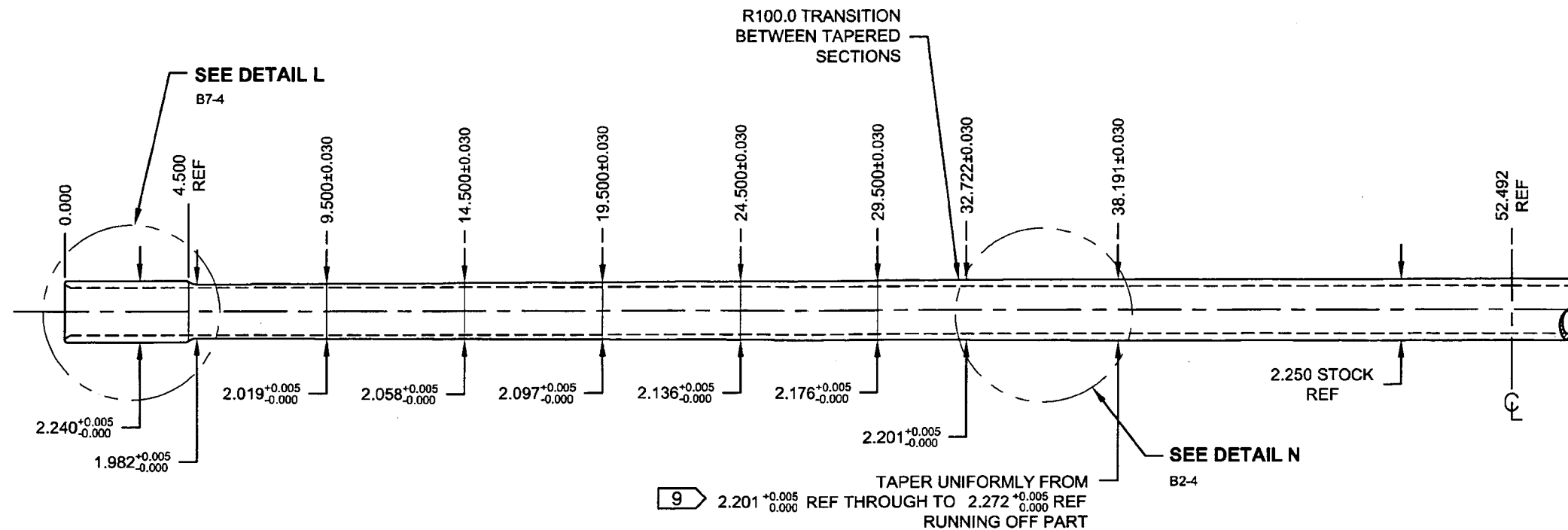
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08/11/12

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-143	SHEET 2 OF 4
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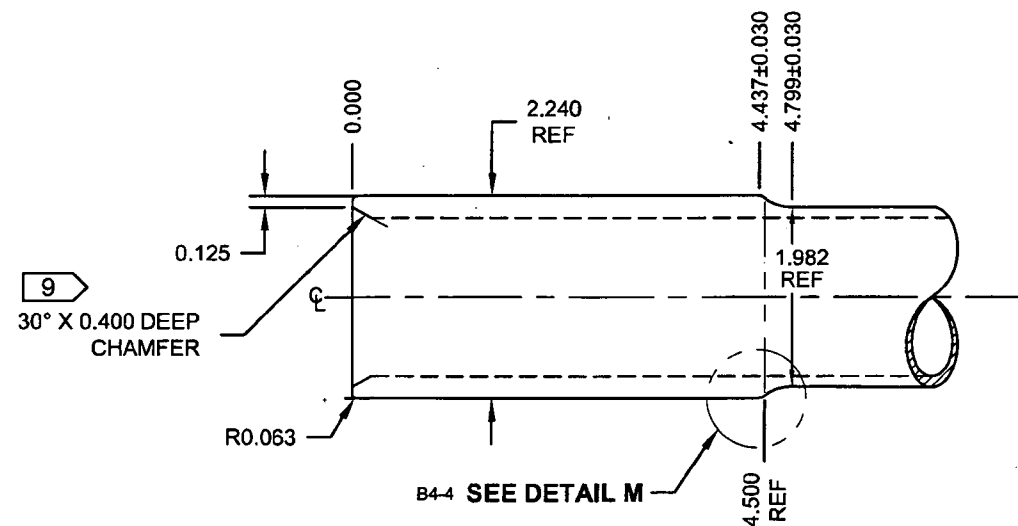


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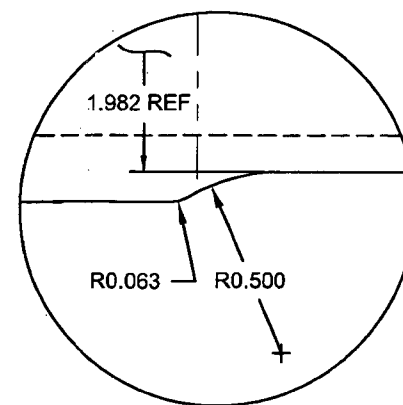
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DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	EE	D206-667-143	SHEET 3 OF 4
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DE APPR.	MP	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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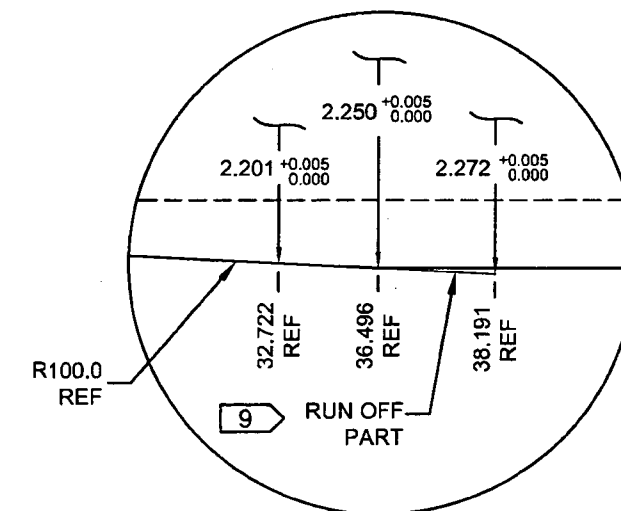
TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4 NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A6-4 NOT TO SCALE

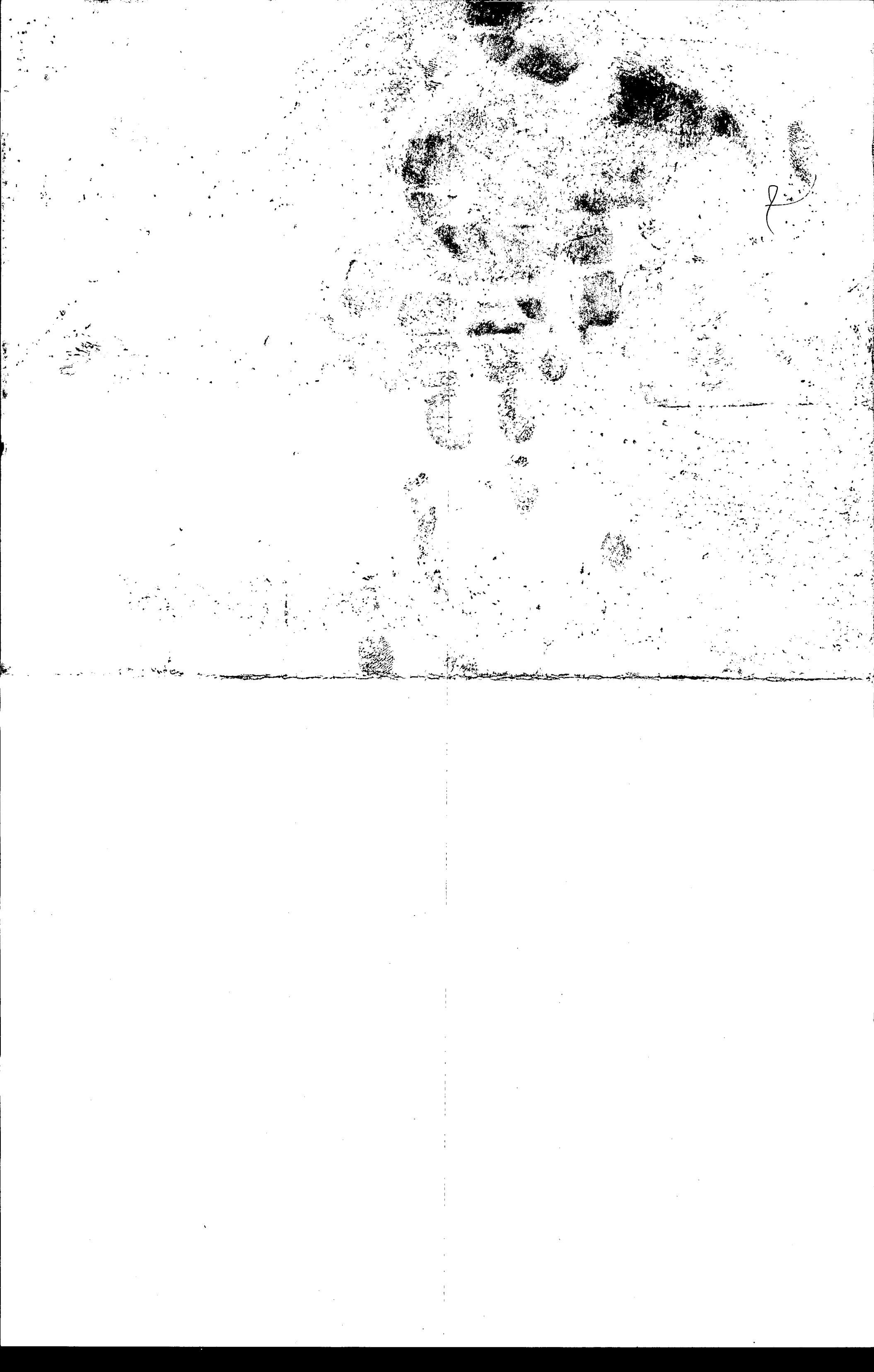


**DETAIL N:
TAPER RUN-OFF**
C4-4 NOT TO SCALE

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44140

RELEASED

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	EF	D206-667-143	SHEET 4 OF 4
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LIQUID PENETRANT TEST REPORT

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PAGE 1 OF 1

CLIENT DART AEROSPACE DATE JAN 16-2009 TIME AM ☐ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-09-001278
ADDRESS 1270 ABERDEEN ST POWO NO. 8000
HAWKES BURY ONT WORK LOCATION MAW SHOP-HAWKES
ACCEPTANCE STD. ASTM1417 REV./DATE 200
PROJECT X-TUBES QSI-038
ITEM(S) EXAMINED 7 ITEMS. FLUORESCENT DIE

JOB DESCRIPTION PROCEDURE NO. LT-XXXX REV./DATE TECHNIQUE NO. LT-XXXX-XXX REV./DATE

PART NO. MATERIAL ALODINED ALUM. THICKNESS
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EM
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT
PENETRANT ZL67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SK052 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE FEB
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE ME
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	PART IDENTIFICATION	ACCEPT SUBJECT
1 -	<u>B-44125-B43052</u>	<u>SC 1</u>
1 -	<u>B-44156-44193</u>	<u>✓</u>
1 -	<u>B-44155-44192</u>	<u>✓</u>
1 -	<u>B-44378-44139</u>	<u>✓</u>
1 -	<u>B-44379-44140</u>	<u>✓</u>
1 -	<u>B-43330-44384</u>	<u>✓</u>
1 -	<u>B-43051-44214</u>	<u>✓</u>

NO INDICATION WAS LOCATED. ON THIS PIECE. WILL BE SANDED TO S.F.M., AND REEXAMINED AT LATER DATE.

44215
M 09 01 19

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Julie Dawson SIGNATURE Julie Dawson DTR # 19804
TECHNICIAN (SIGNATURE): Mike Johnston REPORT REVIEWED BY:
NAME (PRINT): Mike Johnston NAME INIT
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL II SNT LEVEL CGSB LEVEL SNT LEVEL
CGSB REG. NO. 0666 CGSB REG. NO.

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

P.T.S



Client: DART AEROSPACE
Contact: LINDA LACELLE
Location: 1270 ABELDEEN
Description: X-TUBES 7 PCS.
Report #'s: F. L. P. I.

E- 19804.

Form dated Sep 2005

Job #: 188-04-001278
Day: Sun Mon Tues
P.O. #: _____
Vehicle # 579

Date: JAN-16-2009
 Wed Thurs (Fri) Sat
 W.O #: 100-09-001270
 Camera #:

[illegible]

RADIOGRAPHIC UNIT PRICING																							
Weld Diameter												Long Seam						Circ. Seam					
Schedule / Thickness												Thickness						Thickness					
Quantity												Lineal Ft.						Lineal Ft.					

Film: _____ Pcs. 2 3/4 x 17"
 _____ Pcs. 3 1/2 x 17"
 _____ Pcs. 4 1/2 x 17"
 _____ Pcs. 14" x 17"
 _____ Pcs.

Consumables:

Equipment:

Client Representative:

WET FLUORESCENT.
AS PER -

Place a check mark in each safety check area as completed

C/C	CAMERA CHECK
S/E	SAFETY EQUIPMENT CHECK
S/C	SURVEY METER CHECK
B/S	BARRIER & SIGN INSTALLED
C/L	CAMERA LOCKED & SECURELY STORED
C/S	CAMERA SURVEYED AFTER EACH USE

EXPENSES

NOTES

ACUREN 1-877-299-2857

Oakville	(905) 825-8595 • Fax (905) 825-8598
Sarnia	(519) 336-3021 • Fax: (519) 336-8220
Sudbury	(705) 522-1849 • Fax (705) 522-9926
Halifax	(902) 497-3870 • Fax (902) 445-5090
North Bay	(705) 840-8107 • Fax (705) 476-6683
Val D'Or	(819) 856-6789 • Fax (819) 825-9564

Cambridge	(519) 622-3112 • Fax (519) 622-1326
Cornwall	(613) 931-1261 • Fax (613) 931-2777
Saint John	(506) 847-0194 • Fax (506) 847-0194
Thunder Bay	(807) 475-4240 • Fax (807) 577-2017
Gaspé	(418) 392-3618 • Fax (418) 392-4114
Hull	(819) 360-0685 • Fax (819) 827-3513